



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Glossy Black

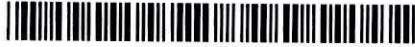
D4273-042
Job Sheet 177998



Part No: D4273-042

Job Qty: 1 ea

Part Name: Basket Base Assembly, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/24/18

Job Tracking No:

Due Date: 6/29/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4279 REV B SHEETS 1,2, D4273 REV F SHEETS 6,7,8,9,10 IPP Rev:A 10.11.16 new issue DD
verf:EC IPP Rev:B 11.01.20 AS PER DWG REV.C DD verf:EC IPP Rev:C 11.03.03 AS PER DWG REV.D DD
verf:EC IPP REV:D 12.07.24 AS PER DWG REV.E DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/29/18	6/29/18	0.00	0.00	Start Up Large Fab-6		<i>D.M.L. 18-6-13</i>
100	Large Fab	1 pcs	6/29/18	6/29/18	0.00	31.15	Large Fab 1		<i>6/18-06-18</i>
110	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC9		<i>CPC</i>
120	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC5		<i>CPC</i>
125	HandFinish	1 pcs	6/29/18	6/29/18	0.00	0.40	HandFinish2		<i>BL 18-6-25</i>
130	Powdercoat	1 pcs	6/29/18	6/29/18	0.00	0.67	Powdercoat <i>x Black Gloss</i>		<i>BL 18-6-25</i>
140	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC3		<i>AL 18-6-25</i>
150	Packaging	1 pcs	6/29/18	6/29/18	0.00	0.00	Packaging3-2		<i>AL 18-6-25</i>
160	QC21-SA	1 Ea	6/29/18	6/29/18	0.00	0.00	QC21		<i>21 JUN 26 2018</i>

Part Op 100 - 1- assemble ribs and handle plates (DO NOT WELD HANDLE IN SECTION N-N ON PAGE 7 DWG D4273, NEED
Descriptions: TO WELDED AFTHER MESH IS INSTALL) weld as per dwg D4273 using DT10317 2- Cut D4279-1 (MADE ON THIS
W/O) base mesh and tack weld all mesh on basket as per dwg D4273 and trim mesh to fit if necessary and trim to clear
fasteners holes on the ends (D4279-5/-9)

130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat

M 188839 START: 1:25 OUT: 3:50 FINISH: 1:40

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	<i>506216</i> <i>5068738</i>
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	<i>5061862</i>
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	<i>5058261</i>
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	<i>5061952</i>
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	<i>5066247</i>
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	<i>5079007</i>
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	<i>5074862</i>
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	<i>5058574</i>
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation	<i>5068416</i>
D4277-19	Rib	1 Ea (1 ea)	90-Start up Operation	<i>5078944</i>
D4277-3	Rib	1 Ea (1 ea)	90-Start up Operation	<i>5015591</i>
D4277-5	Rib	2 Ea (2 ea)	90-Start up Operation	<i>5078915</i>
D4277-9	Rib	1 Ea (1 ea)	90-Start up Operation	<i>5047345</i>
D4278-041	Upper Rib Assembly-Hoop	1 Ea (1 ea)	90-Start up Operation	<i>5017978</i>
D4278-045	Rib Assembly, Fwd Cham	2 Ea (2 ea)	90-Start up Operation	<i>5075248</i>
D4278-047	Upper Rib Assembly-Straight	1 Ea (1 ea)	90-Start up Operation	<i>5017734</i>

D4279-5	End Mesh, Basket	1 Ea (1 ea)	90-Start up Operation
D4279-7	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation
D4279-9	End Mesh, Basket	1 Ea (1 ea)	90-Start up Operation
D4306-044	Rib Assembly, RH	1 Ea (1 ea)	90-Start up Operation
D4306-045	Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4306-1	Rib	1 Ea (1 ea)	90-Start up Operation
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	90-Start up Operation

SO 57508
SO 49915
SO 24968
SO 31398
SO 37162
SO 44670
SO 54936
SO 60244

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	73	0
	D3913-1	1	5	0
	D3913-15	1	17	0
	D3913-3	1	7	0
	D3913-9	1	10	0
	D3916-5	3	15	0
	D4016-1	3	10	0
	D4017-7	3	72	0
	D4021-1	3	67	0
	D4277-19	1	1	0
	D4277-3	1	2	0
	D4277-5	2	4	0
	D4277-9	1	2	0
	D4278-041	1	2	0
	D4278-045	2	0	0
	D4278-047	1	2	0
	D4279-5	1	6	0
	D4279-7	2	5	0
	D4279-9	1	2	0
	D4306-044	1	4	0
	D4306-045	1	6	0
	D4306-1	1	8	0
	D4672-1	2	30	0
	M304EX0.75-16F	32	1,570	0

Part Specifications

Specifications could not be found.

WORK ORDER NON-CONFORMANCE / UPDATE



DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION Rework ☐ ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ ☐ Machining ☐ ☐ Thermofforming ☐ ☐ Large Fab ☐ ☐ Cross tube ☐ ☐ Small Fab ☐ ☐ Finishing ☐ ☐ Composite ☐ ☐ Water Jet ☐ ☐ Prod. Eng. Coord. ☐ ☐ Rec/Store/Packaging ☐ ☐ Supplier ☐ ☐		Engineering ☐ ☐ Quality ☐ ☐ Other ☐ ☐	
Part No. _____						
NCR No. _____						

Date: _____	Step #: _____	QTY Effective: _____	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition
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Completed By	Lead hand / Supervisor Approval Verification	QC / QA Coordinator Approval
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Job No 177998



Container No: S080826



Part: D4273 - 042
 Job No: 177998
 Serial No/Batch: S080826
 Revision:
 Inspector:
 Exp Date:
 Instructions:

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 1270 Aberdeen Street
 Hawkesbury, ON K64 1K7
 CANADA
 TEL.: 1 613 632 - 5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Date: 06/13/18

Master Unit	Past Due	OTHER:
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Positioned Wrong	☐
Outside Dimensions	☐
Over/Under tolerance	☐
Part Incorrect	☐
Part Lost/Missing	☐
Part Moved	☐
Drawing	☐
Finish	☐
Misread	☐
Turning Sequence	☐